

Work Order ID 80434

80434

Page 1

February-21-12 9:13:33 AM

Item ID: D3793-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearshoe

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/02/12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3793								
304. <u>OK</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

R12-2-28

(12)

R12-2-29

Sr/la/26

(H2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary
2-Form on Brake as per Dwg D3793 using Jigs

St 12/03/01

12

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

St 12/03/01

12

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:50
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:20

12 X 4 m-f 12/03/02

M118489

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Work Order ID 80434***80434***

Page 3

February-21-12 9:13:33 AM

Item ID: D3793-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12 12 12-3-2

170

Identify as per dwg & Stock Location: FP-1

0.00

170

Packaging

Memo

0.00

Packaging

12 2 2 12/03/02

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MCU 12/03/02

12-03-2
(12)

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NOTE: Date & initial all entries

Picklist Print

Page 1

February-21-12 9:13:37 AM

Work Order ID: 80434

80434

Parent Item: D3793-3

D3793-3

Parent Item Name: Wearshoe

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	233.0165	1.2828	10.80253	6		

M304S20GA

304/316 .040 Sheet

12-2-28

Location

Loc Qty

Loc Code

MAT020

233.0165

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

118

120604

~~12~~ (12)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80434
Description: Wearshoe		Part Number:	D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.191	2		✓ B02	
0.300 x 0.300	+/-0.010	3054.301	2		✓	
1.885	+/-0.010	1.885	2		✓	
4.389	+/-0.010	4.389	2		✓	
6.547	+/-0.010	6.547	2		✓	
6.00	+/-0.030	6.00	2		✓	
6.75	+/-0.030	6.75	2		✓	
2.000	+/-0.010	2.000	2		✓	
4.750	+/-0.010	4.750	2		✓	
9.500	+/-0.010	9.500	2		✓	
14.250	+/-0.010	14.200	2		✓	
17.750	+/-0.010	17.750	2		✓	
26.735	+/-0.010	26.735	2		✓	
Ø0.531 x 0.780	+0.008/-0.001	.531 x .783	2		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-2-29	Date: 12/02/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

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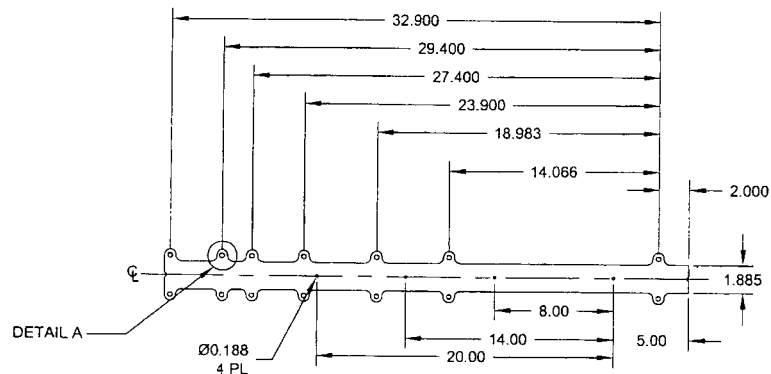
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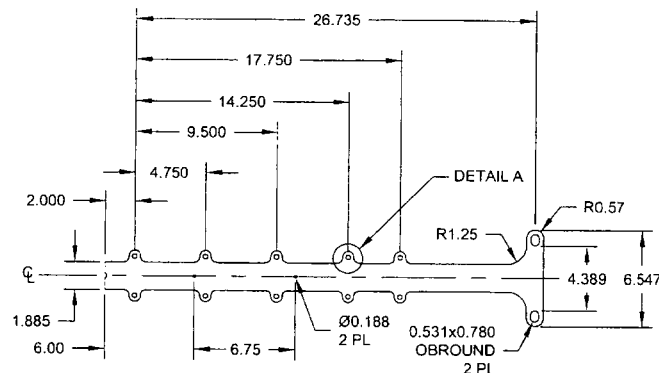
NOTE: Date & initial all entries

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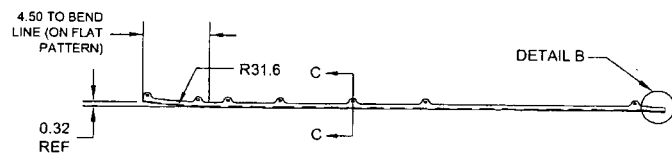
D



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

80434 M.C.J
12/02/21

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE		08.05.14
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR THE DISSEMINATION OF ANY INFORMATION WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

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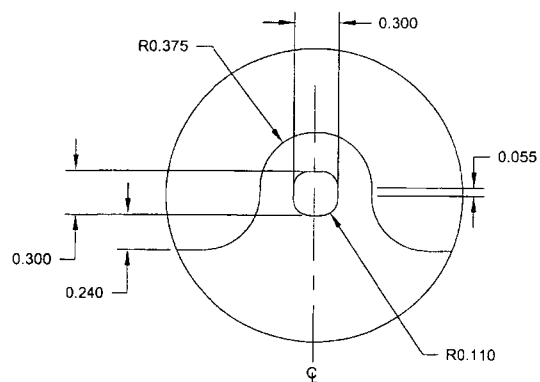
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

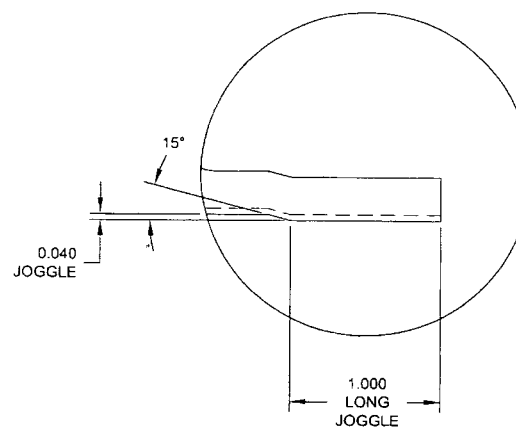
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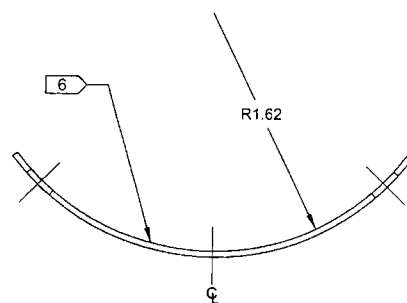
80434



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

RELEASED
08-05-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
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